

# Work Order ID 55141

January 7, 2010 8:36:07 AM



Page 1

Item ID: D3281-1

Accept

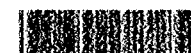


Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Fwd LH

Start Date: 01/01/2010 Start Qty: 10.00



Item ID:

Required Date: 12/31/2010 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

*RA*

Date: 10-1-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3281

Rev D

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

*BB*  
10/01/20  
(X10)

110

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3281 Hand Folio FTA 011 □ Dwg. Rev.

*D* □ Folio Rev. *D*

*BB*  
10/01/20  
(X10)

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*BB*  
10/01/20  
(X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

...the ...

January 7, 2010 8:36:07 AM

**Accept**

~~Setup~~ **Start**

**Stop**

\_\_\_\_\_



**Cust Item ID:**



**Customer:**

**Reference:**

**Run Start**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Abstract**

0.00

[illegible]

0.00

### Metro

### Trim to Finished Dimensions

0.00

11-00000

0.00

QC

## Memo

BB  
10/01/25  
X10

0.00

**THE**

0.00

OC

## Negro

## Quality Control

→ 8/10/26

410

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 55141**

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Page 3

Item ID: D3281-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Floor Protector, Fwd LH

Start Date: 07/01/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00

10-1-27

10x

SQ



Packaging

Packaging

Memo

0.00

Packaging

170

0.00

QC21- Final Inspection - Work Order Release



QC

Memo

0.00

Quality Control

10/01/27  
MF  
10-1-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

January 7, 2010 8:36:11 AM

Page 1

Work Order ID: 55141



Parent Item: D3281-1



Parent Item Name: Floor Protector, Fwd LH

Start Date: 07/01/2010

Required Date: 15/01/2010

Comments:

IPP Rev. A 04.07.01 New issue KJ/JLM

Start Qty: 10.00

Required Qty: 10.00

IPP Rev B. 07.16.2007 Thermoflex in house DL

IPP Rev C. 08.02.06 To reflect updated Dwg. DL

IPP Rev. D 08.04.15 Material Change DL

MLEXS.093-F6006-02

Purchased

No

100

sf

1,376.930 43.3300



GE PLASTICS LEXAN SHEET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

1376.93

106751

6.26

110877

1370.67

BB  
10/01/20  
X10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	53141
<b>Description:</b> Floor Protector, Fwd LH		<b>Part Number:</b>	D3281-1
<b>Inspection Dwg:</b> D3281 <b>Rev:</b> D		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875" Go/No Go	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

<b>Measured by:</b>	BD	<b>Date:</b>	10/01/25
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#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.6	+/-0.100	18.575	✓			
17.1	+/-0.100	17.1	✓			
11.7	+/-0.100	11.7	✓			
0.95	+/-0.030	.957	✓			
0.25	+/-0.030	.267	✓			
0.030	Min	.057	✓			
0.070	Min	.086	✓			

<b>Measured by:</b>	BD	<b>Date:</b>	10/01/25
<b>Audited by:</b>	W/L	<b>Date:</b>	10/01/25
<b>Prototype Approval:</b>	N/A	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL	

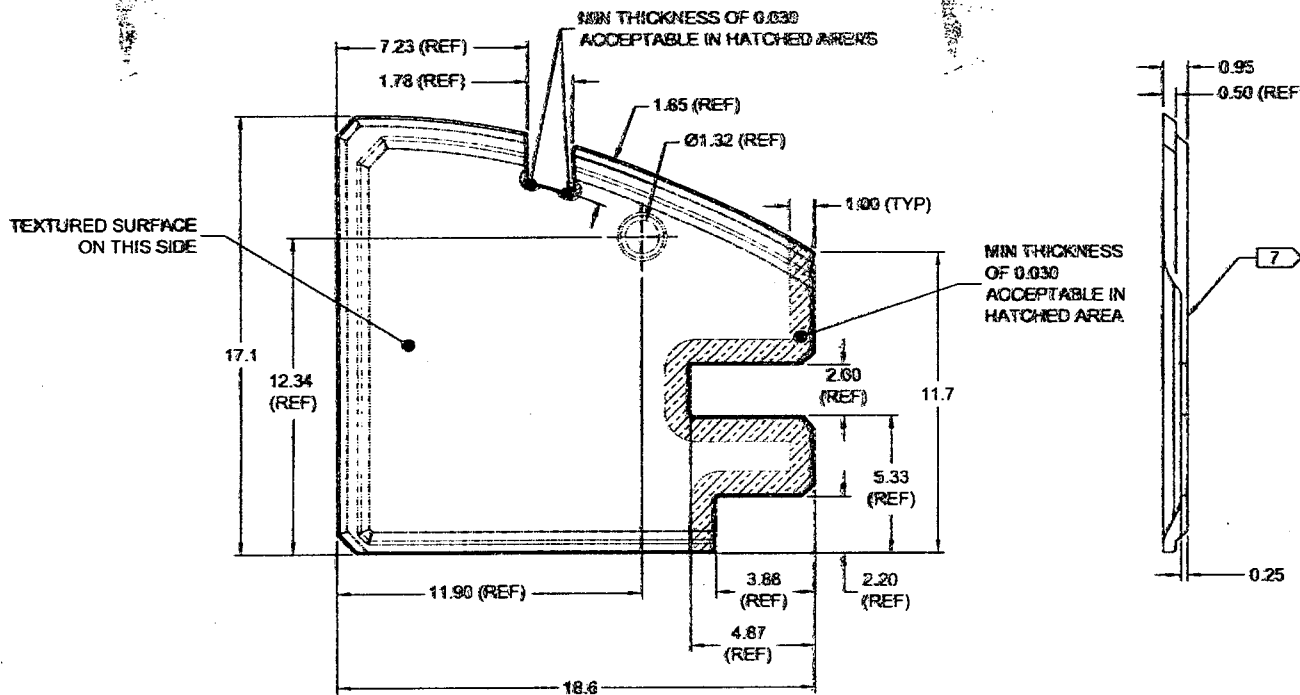
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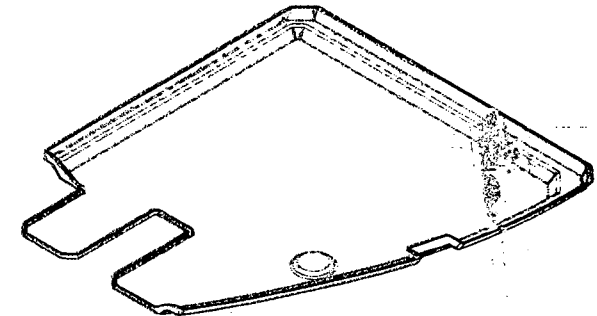
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3281-1 FLOOR PROTECTOR**



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 55141

B-10-1-07

11-05-04/11 WPD

**31-1 NOTES:**  
HERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED  
MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)

FINISH: NONE  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES: 0.010 MAX  
IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS  
WEIGHT: 0.95 lb

D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS. COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	DRAYN	DART AEROSPACE LTD HAMMERSLEY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3281	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	08.03.28	COPYRIGHT © 2004 DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD	

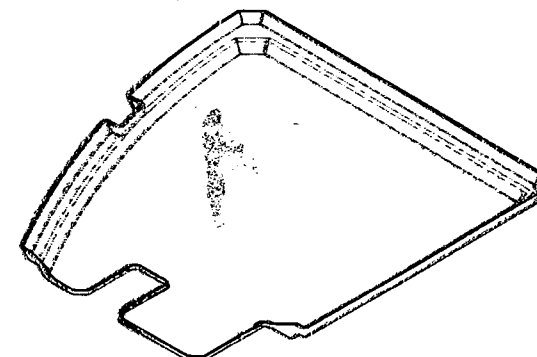
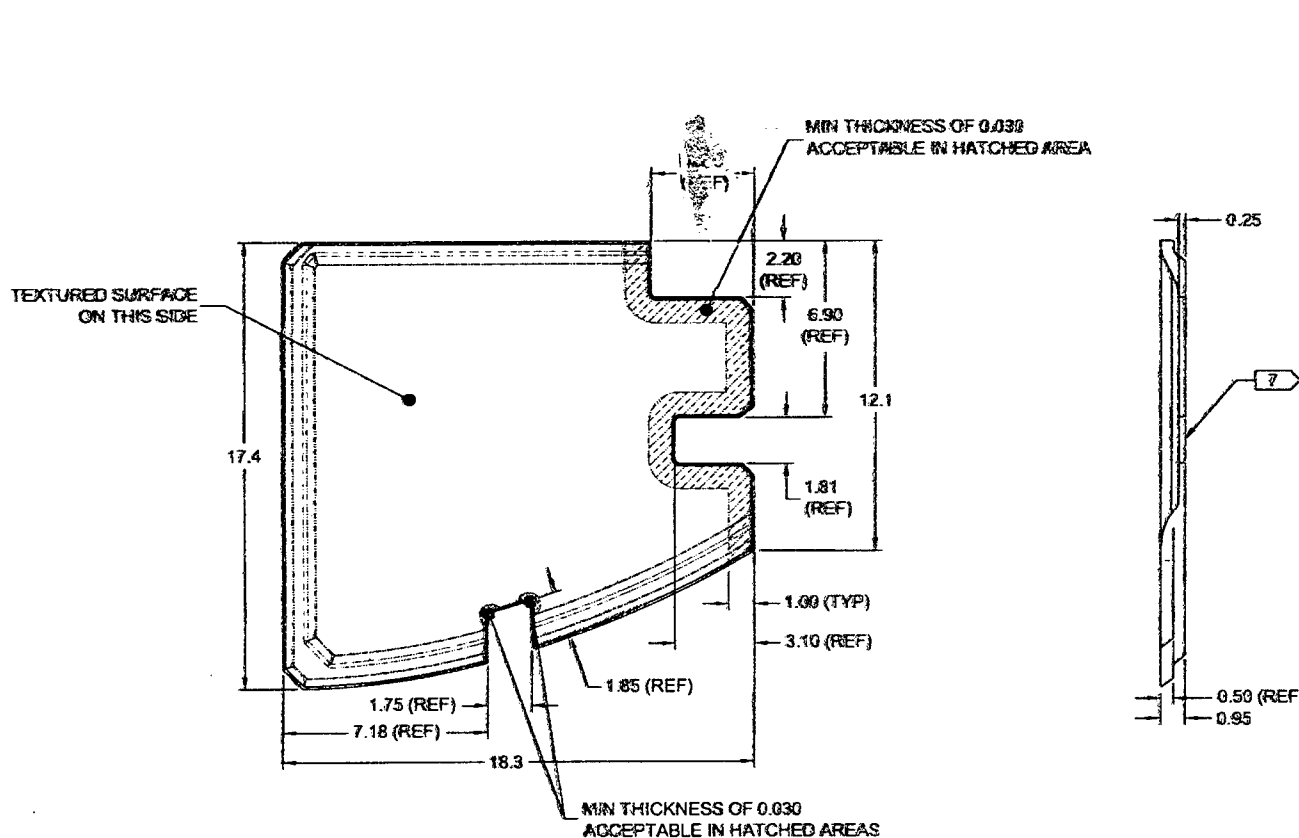
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# **D3281-2 FLOOR PROTECTOR**

**21-2 NOTES:**  
 HERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN  
 MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED  
 MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
 (REF DART SPEC MLEXS 093-F6006-02)

FINISH: NONE  
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 UNITS: INCHES UNLESS OTHERWISE NOTED  
 BREAK SHARP EDGES: 0.010 MAX  
 IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" AND BATCH NUMBER "XXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS  
 WEIGHT: 0.97 lb

**DART AEROSPACE LTD**  
 HAWKESBURY, ONTARIO, CANADA

DESIGN	40	DART AEROSPACE LTD	REV. D
DRAWN	41	HAWKESBURY, ONTARIO, CANADA	
CHECKED	42	DRAWING NO.	D3281
MFG. APPR.	43	TITLE	FLOOR PROTECTOR
APPROVED	44	SCALE	NTS
DATE	08.03.28		

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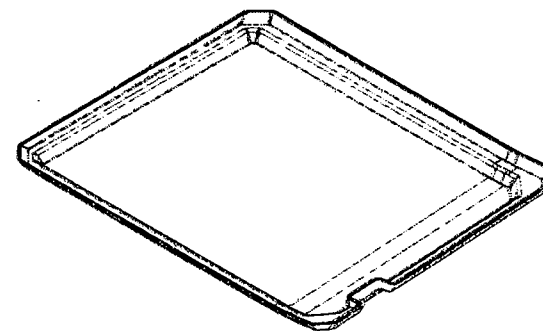
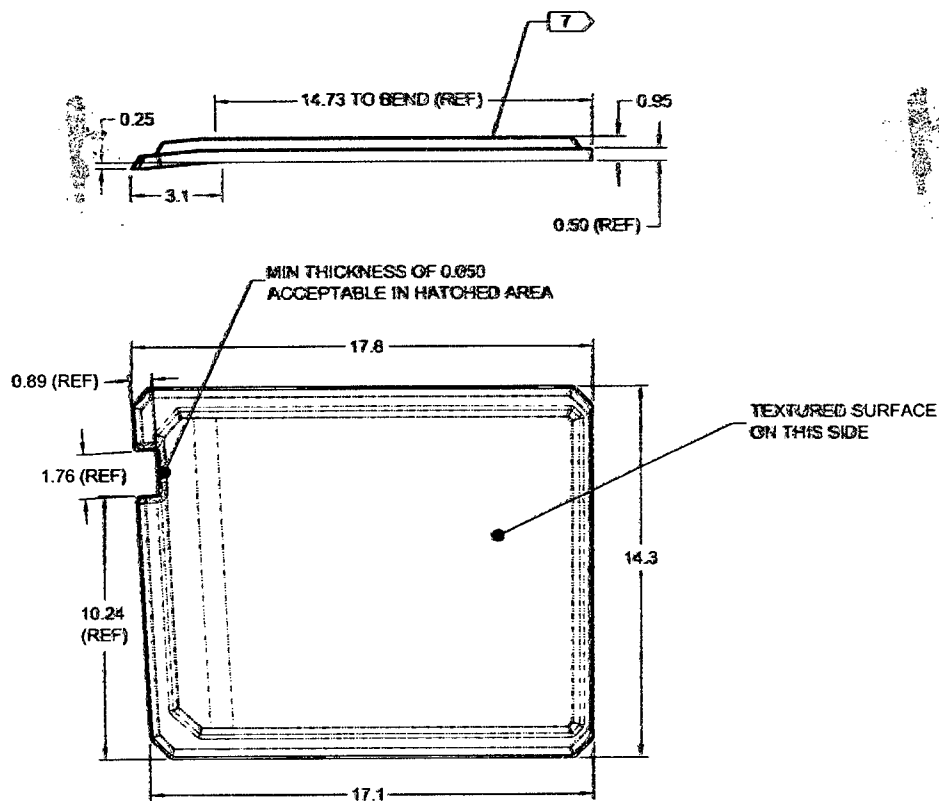
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



### D3281-3 FLOOR PROTECTOR

#### NOTES:

HERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN  
 MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED  
 MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
 (REF DART SPEC MLEKS.083-F6006-02)

FINISH: NONE

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.010 MAX

IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "XXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS

WEIGHT: 0.87 lb

DESIGN	40	<b>DART AEROSPACE LTD</b>	
DRAWN	AC	BARRISBURRY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. D
MFG. APPR.	MD	D3261	SHEET 3 OF 4
APPROVED	MD	TITLE	SCALE
DE. APPR.	MD	FLOOR PROTECTOR	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

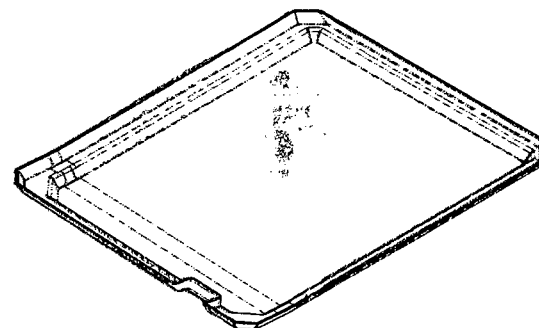
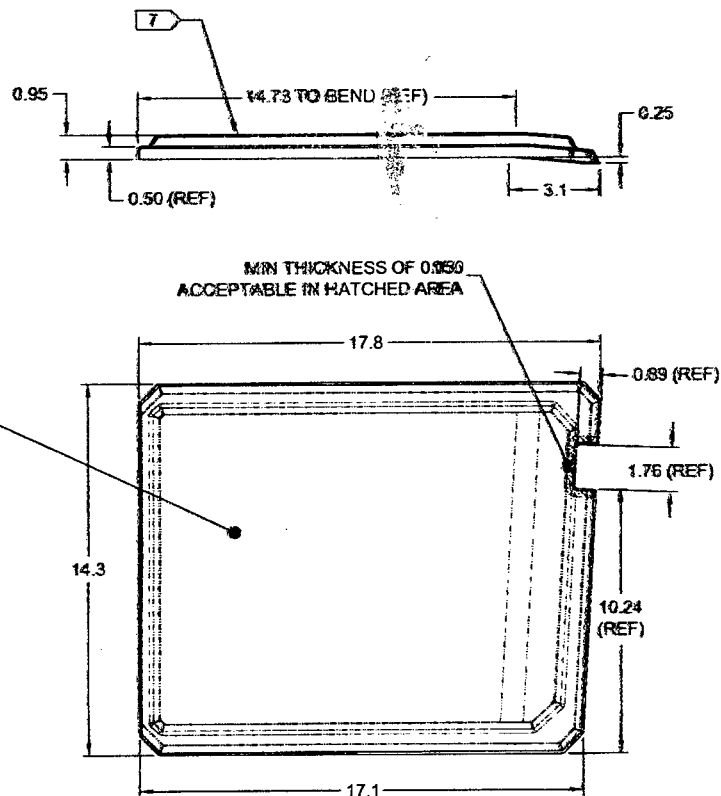
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





# **D3281-4 FLOOR PROTECTOR**

## **11-4 NOTES:**

HERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022. TRIM AS SHOWN  
 MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED  
 MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
 (REF DART SPEC MLEXS.093-F6006-02)

FINISH: NONE  
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 UNITS: INCHES UNLESS OTHERWISE NOTED  
 BREAK SHARP EDGES: 0.010 MAX  
 IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS  
 WEIGHT: 0.87 lb

**DART AEROSPACE LTD**  
 HAWKESBURY, ONTARIO, CANADA

DESIGN	98	DRAWING NO.	D3281	REV. D
DRAWN	PH			SHEET 4 OF 4
CHECKED	PH	TITLE	FLOOR PROTECTOR	SCALE
MFG. APPR.	PH			NTS
APPROVED	PH			
DATE	08.03.28			

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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